

Work Order ID 57740

April 14, 2010 11:35:36 AM

Page 1

Item ID: D3296-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Panel

Start Date: 14/04/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: RFDate: 10-4-14

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3296

☐ Dwg Rev:A☐ Prog Rev:A☐ 2-

Deburr if necessary

204 1063

B 10-4-20

(17)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-4-20

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/04/20

(416)

PD →

W/O: 57740		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/4/20	# 170	Took Qty +1 For QC inspection template	8	10/04/20	4/		8 10/04/20








Part No: D3296-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April 14, 2010 11:35:36 AM

Item ID:	D3296-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Door Panel				Stop	
Start Date:	14/04/2010	Start Qty: 10.00		Cust Item ID:		
Required Date: 22/04/2010		Req'd Qty: 10.00		Customer:		
Reference:						
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00				(16x)			
Small Fab	Memo	0.00	⇒ m-h 10/04/20						
Small Fab	Deburr								
140 	Chemical Conversion Coat per QSI005 4.1	0.00				16	Ø		
HandFinish	Memo	0.00	9/11 10/04/20						
Hand Finishing			⇒ m-h 10/04/20 (16x)						
150 	QC3- Inspect Part Finish	0.00				16	Ø		
QC	Memo	0.00	JL 10/04/20						
Quality Control									

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Work Order ID 57740

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Page 3

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Panel

Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: ST186

0.00



Packaging

Memo

0.00

Packaging

15. MF 10-4-23

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/23 MF 10-4-23

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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:35:41 AM

Page 1

Work Order ID: 57740

Parent Item: D3296-3

Parent Item Name: Door Panel

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:E Now on Waterjet 06-11-02 JLM

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	260.0000	6.8758	11.7		



2024-T3 .063 sheet



18 10-4-20

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT22

260

111787

2

113866

24

113867

42

114351

192

113867

17

W/O:		WORK ORDER CHANGES					
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57746

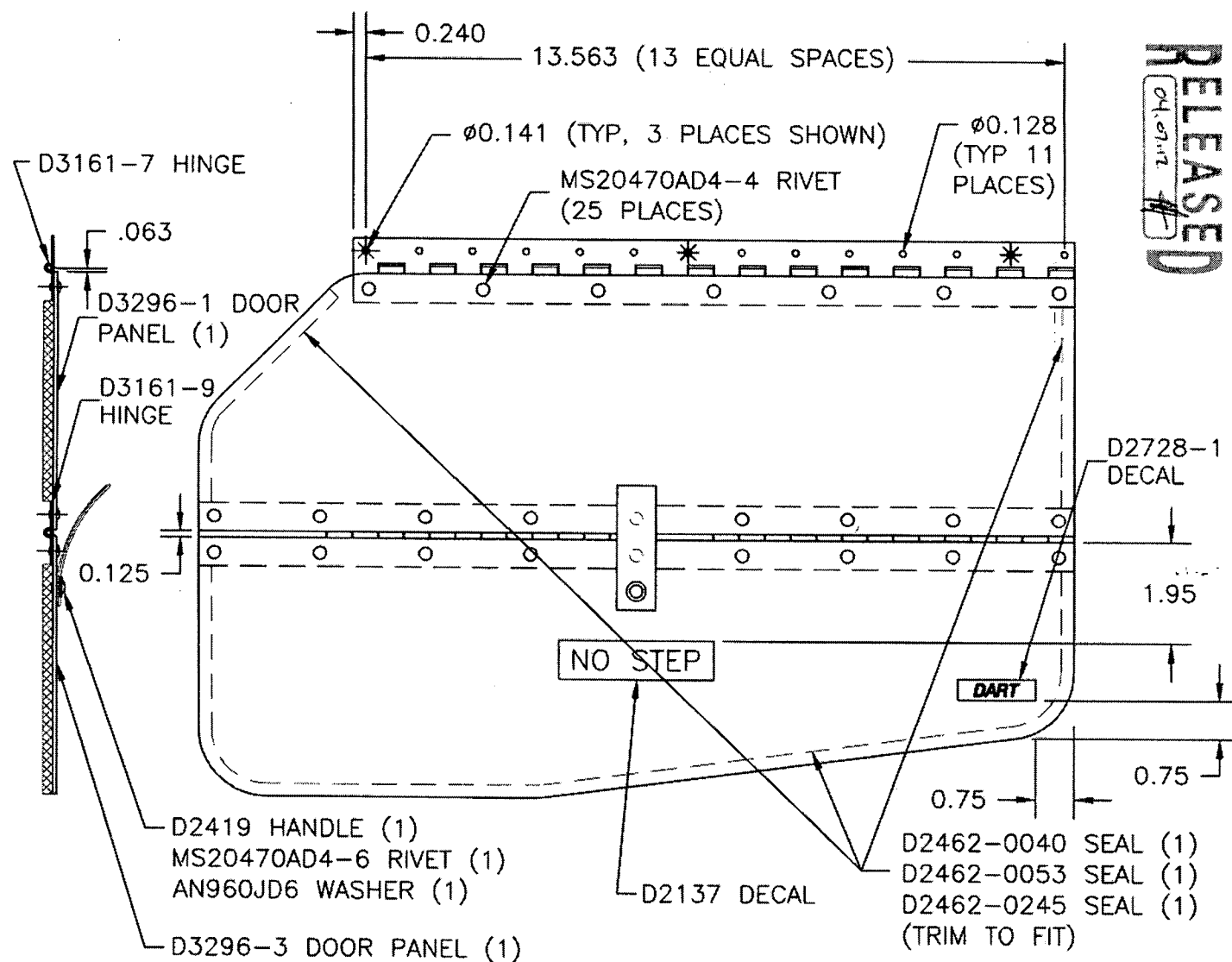
RELEASED
04.07.12

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UNCONTROLLED COPY
SUBJECT TO A
WITHOUT
WORK C
NO. 57746



P10-4-14

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296
DATE 04.06.28		TITLE DOOR ASSEMBLY
A	04.06.28	NEW ISSUE
		REV. A 1 OF 2 SCALE 1:3

**D3296-041 DOOR ASSEMBLY**

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

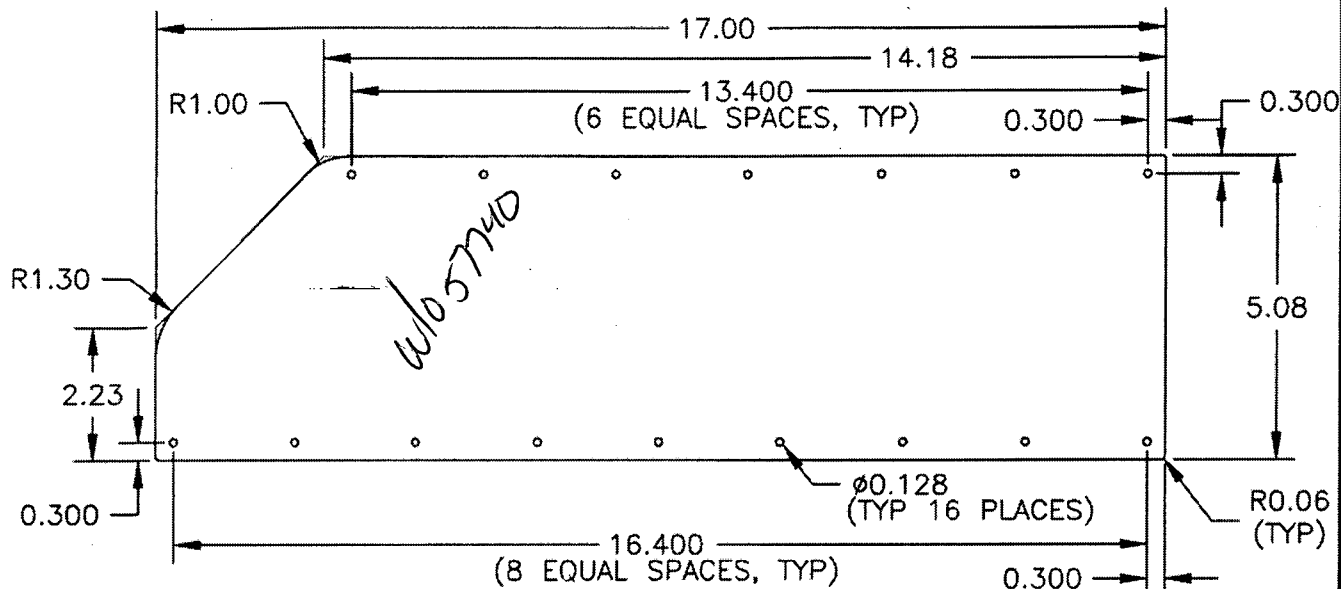
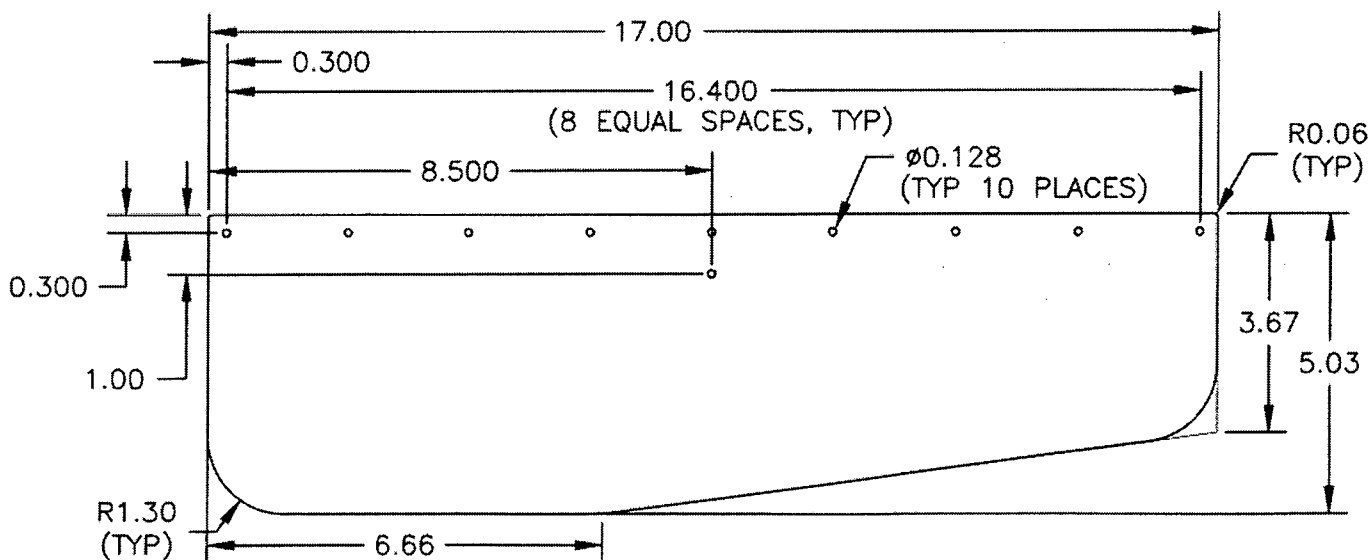
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NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3

**D3296-1 DOOR PANEL****D3296-3 DOOR PANEL****D3296-1 AND D3296-3**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
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